

Work Order ID 147873

Friday, June 17, 2016 8:23:40 AM

147873

Page 1

Item ID: D4952-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 6/14/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: **JUN 17 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4952	A								
110	Large Fab	0.00							
110									
Large Fab	Memo	0.27							
Large Fab	1- PICK D4952-1 AND D4379-3								
	2- Weld hardcoat and cups as per dwg using DT10002								
	2059B hardcoat batch: <u>130145</u>								
	304/316 S.S. ROD batch: <u>116577</u>								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

12 16-08-17
12

(12) 1608-17 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Friday, June 17, 2016 8:23:40 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

8

8

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.

0.00

Memo

0.03

OC

Quality Control

Identify as per dwg & Stock Location:

0.00

Memo

0.01

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

Memo

0.13

OC

Quality Control

**DAS
21
9-89**

AUG 18 2016

**DAS
21
9-89**

AUG 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Friday, June 17, 2016 8:23:44 AM

Page 1
1

Work Order ID: 147873

147873

Parent Item: D4952-041

D4952-041

Parent Item Name: Wearplate Assembly

Start Date: 6/14/2016

Required Date: 6/17/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.09.30 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4379-3		Manufactured	No				Each	58.0000		24			
D4379-3									**				16-08-11 JBL
Wearplate Cup													

Location	Loc Qty	Loc Code
WA002-147697	58	
135592	20	
-141353	38	

18
18

D4952-1		Manufactured	No				Each	8.0000		8			
D4952-1									**				16-08-11 JBL
Wearplate													

Location	Loc Qty	Loc Code
WA001 125898	8	
121083	8	
145893		
147950		

3
3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

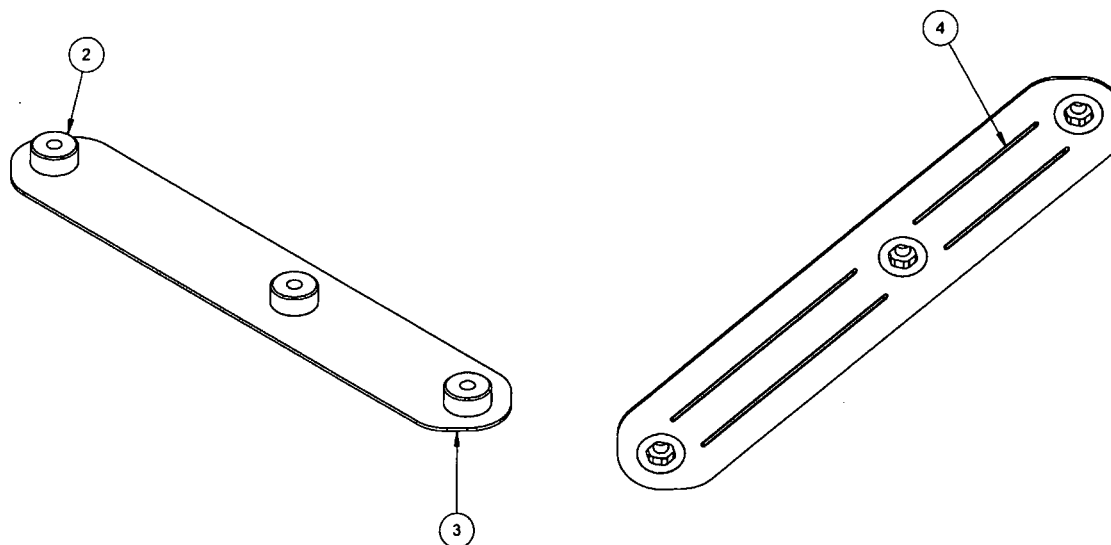
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
			OTHER : _____					

ITEM	QTY	P/N	DESCRIPTION
1	X	D4952-041	WEARPLATE ASSEMBLY
2	3	D4379-3	WEARPLATE CUP
3	1	D4952-1	WEARPLATE
4	A/R	2059B	HARDCOAT



D4952-041 WEARPLATE ASSEMBLY

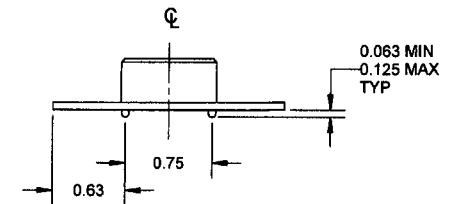
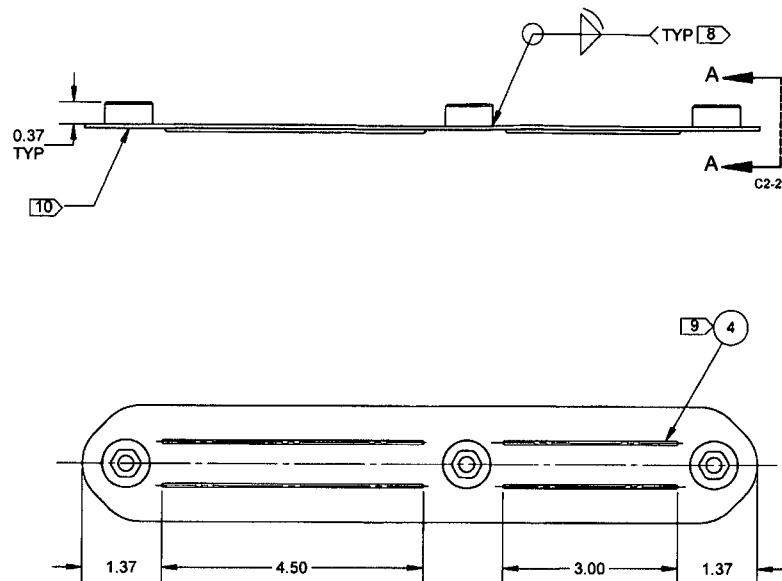
TOP COPY
 147873 MJS
 160617

RELEASED
 2013-10-30
 mp

A		NEW ISSUE		VS	13.09.23
REV.	DESCRIPTION			BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4952 TITLE WEARPLATE		REV. A	
DRAWN	VS			SHEET 1 OF 3	
CHECKED	DC			SCALE	
MFG. APPR.	DD			NTS	
APPROVED	HS				
DE APPR.	DS				
DATE	13.10.17				

APPROVED

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SECTION A-A
SCALE 1:1

C4-2

D4952-041 WEARPLATE ASSEMBLY
WELDING DETAIL

RELEASED
2013-10-30
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.44 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 4 PL
- 10) D4379-3 FLUSH WITH SURFACE

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D4952	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

